

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016889**Date Inspected:** 03-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**Segment # 10AE ~ 10BE**

This QA inspector observed, ZPMC qualified welding personnel identified as 040320 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP151-001-018; ZPMC CWI is identified as Mr. Liu Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114-FCM-1. See the attached Photo.

Segment # 10AE ~ 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 040367 perform Flux Core Arc Welding (FCAW), weld joint identified as SP695-001-051; ZPMC CWI is identified as Mr. Liu Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

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Segment # 10BW ~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 041713 perform Submerge Arc Welding (SAW), weld joint identified as OBW10A-003; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223 (2) 1T-1.

Segment # 10BW ~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 040609 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW10C-002; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223T.

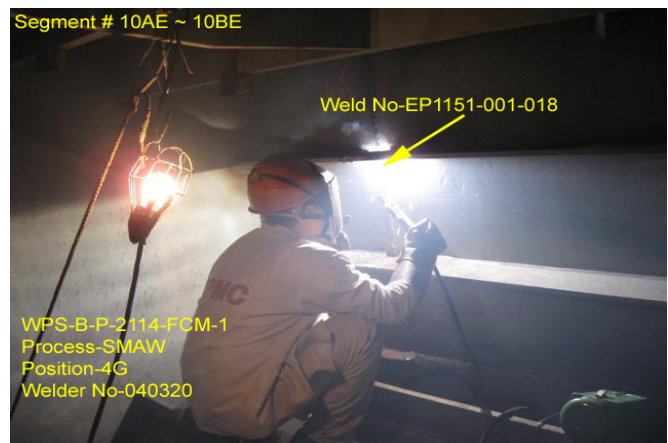
Segment # 10BW ~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP049-001-020; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1.

Segment # 10AW ~ 10BW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Ultrasonic Testing (UT) on Deck Plate to Deck Plate Transverse CJP Weld in OBG segment 10AW ~ 10BW at panel point 88 to 89. See the attached Photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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